



DESIGN #	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. DSI 9338	REV. A SHEET 1 OF 1
DATE 06.06.02		TITLE CROSSTUBE REPAIR	SCALE NTS
A	06.06.02	NEW ISSUE	

DART SERVICE INSTRUCTION

TO AMEND IIN-D205-594 REV. A/B/C

AND ICA-D205-594 REV. 0/1/2

REF. CANADIAN STC: SH03-6 ISSUE 1/2/3

REF. FAA STC: SR01742NY

To repair crosstubes where holes have been elongated beyond limits identified in ICA-D205-594, it is acceptable to perform one of the following repairs:

- 1) Upsize the holes in both the saddles & the crosstube to $\varnothing 0.386^{+0.005}_{-0.000}$ and replace AN5-xxA bolts with AN6-xxA bolts. Also replace MS21042L5 and AN960JD516 with MS21042L6 and AN960JD616.
- 2) Upsize the holes in the crosstube to between $\varnothing 0.438$ and $\varnothing 0.500$ and fabricate bushings from AISI 303 stainless steel with an I.D. of $\varnothing 0.323^{+0.005}_{-0.000}$ to press into the enlarged holes. The bushing may go right through the crosstube.

Method 2) is recommended to preserve compatibility with future crosstubes.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 06.06.02
CERT. NO.: SH03-6
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